HELIGRIP inserts, IC830, Groove width w / corner radius R: 3/0,2mm

Order data

Order number	273405 3/0,2
GTIN	7291075029017
Item class	26C

Description

Version:
Positive chip breaker. Soft cut. Reduced cutting forces.
Application:
For axial and radial grooving, parting off and internal machining. (HELIGRIP inserts for axial grooving application only compatible with HFHR holder).
Suitable for:
Toolholder No. 273766 – 273768.
Note:
The minimum order quantity corresponds to one pack unit quantity (VPE) or a multiple thereof.

Technical description

Groove width w	3 mm
Corner radius R	0.2 mm
Feed rate f when parting off	0.07 - 0.11 mm/rev.
Tolerance groove width w	0.05 mm

INSL	15.8 mm
Feed rate f when turning	0.14 - 0.18 mm/rev.
Feed rate f when facing	0.1 - 0.2 mm/rev.
Feed rate f when axial grooving	0.08 - 0.2 mm/rev.
Cutting depth a_p	0.25 - 1.8 mm
Series	HELI-GRIP
Cutting depth $a_{p\,max}$	1.8 mm
Cutting depth $a_{p\,min}$	0.25 mm
Manufacturer's designation	GRIP 3002Y IC830
Number of changes/inserts	1
Tool material	Carbide
Indexable insert profile	neutral
Finishing/roughing assignment	Finishing
Coating technology	PVD
Main application	UNI
Cutting conditions	heavily interrupted
Chip breaker	ZC
Cutting speed v_c main application	50 - 140 m/min
Type	IC830
Type of product	Indexable insert for grooving